

SPUT 64118-1 Lash

Wednesday, November 24, 2010 2:50:00 PM

Page 1

Item ID: D3859-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 11/25/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: UMF

Date: 10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

304 . 063

I-Cut as per Dwg D3859 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B3 10-11-25

78

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B3 10-11-25

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Scrub

78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 64118

Wednesday, November 24, 2010 2:50:00 PM

Rush



Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

1-Weld D3009-3 cups as per dwg D3859 ☐ A/R 316L stainless steel rod
Batch: 1114509 ☐ 2-Weld hard facing as per Dwg D3859 ☐ A/R
2059B Hard Coat rod Batch: 1116044 ☐ *****use
DT9462 for welding*****

12 10-11-29 (x6)

140

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

BE 10.11.29

60

150

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8.10.11.29

(x6)

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112588

Memo

0.00

START TIME: 11:00

320° FINISH TIME:

OVEN TEMPERATURE:

4:30

6 BR 10-11-22

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> JU 10/4/30

6 Ø

180



Packaging

Packaging

Identify as per dwg & Stock Location: 499

0.00

Memo

0.00

18/11/30 (Ex) \$D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/12/01

B/10-1130

6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 2:49:59 PM

Page 1

Work Order ID: 64118

Parent Item: D3859-041

Parent Item Name: Wearplate



Start Date: 11/25/2010

Required Date: 12/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

133.9000

0.85

6.8



304/316 Sheet .063

B/C-11-26

Location

Loc Qty

Loc Code

MAT

133.9

111323

0

115688

2.9

115953

131

8

D3009-3

Manufactured

No

130

Each

185.0000

6

48



Cup

115953

EC

10-11-09

Location

Loc Qty

Loc Code

WA

185

42377

185

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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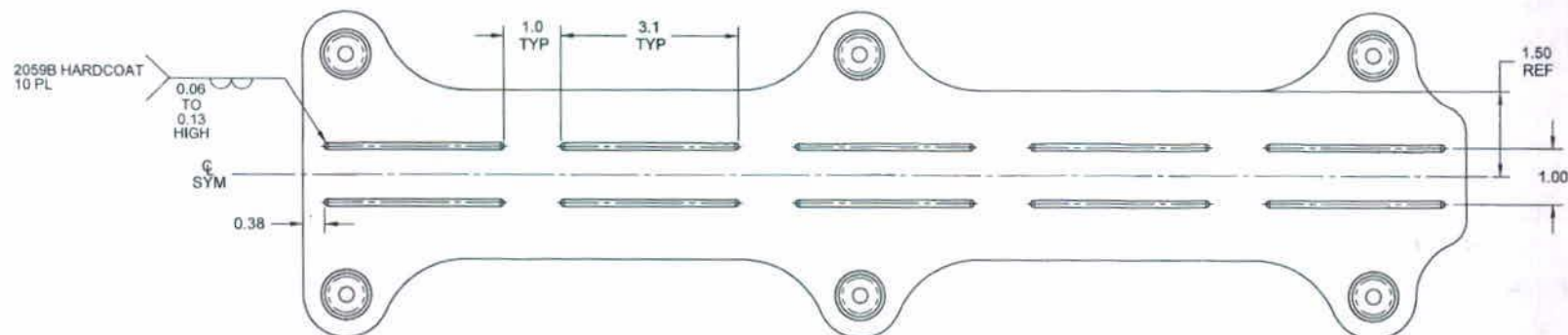
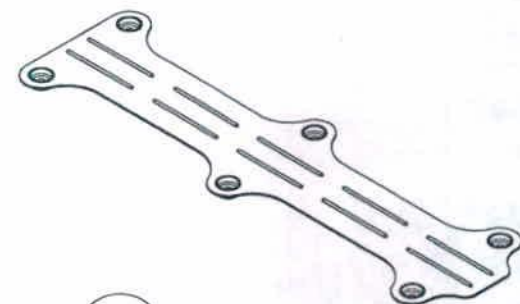
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

#64118



D3859-041 WEARPLATE

RELEASED
#09 01.26

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.46 lbs
 - 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3859 SHEET 1 OF 2
TITLE SCALE
WEARPLATE NTS

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Technical drawing of a mechanical part, likely a bracket or plate, showing dimensions and features. The part is symmetrical about a vertical centerline.

Key dimensions and features:

- Overall width: 20.40
- Overall height: 5.75 REF
- Central slot width: 9.00
- Three circular holes with diameter $\text{Ø}0.879$ and 6 PL
- Radii: $R1.50$ TYP, $R0.75$ TYP, $R1.00$ TYP, $R0.50$ TYP
- Handwritten number: #6418

RELEASED
09.01.26

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK),
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 1.29 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA DRAWING NO. D3859 TITLE WEARPLATE SCALE NTS	REV. A
DRAWN	<i>JS</i>		SHEET 2 OF 2
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
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